

Work Order ID 133237

133237

Page 1

Wednesday, May 27, 2015 2:47:27 PM

Item ID: PB67-43001-79 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Blade Support Assembly
Start Date: 5/27/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/5/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: UMF Date: 15-5-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								

100 Weld per dwg A/R Aluminum rod Batch: 112939 0.00
Large Fab
100
Large Fab Memo 0.00
Large Fab Weld assembly as per dwg PB67-43001
USE DT10018

2 15-6-8

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
QC Memo 0.00
Quality Control

17 15-06-09 PD

120 QC5- Inspect part completeness to step on W/O 0.00
120
QC Memo 0.00
Quality Control

2 15-06-09 PD

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Wednesday, May 27, 2015 2:47:27 PM

Item ID: PB67-43001-79

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Blade Support Assembly

Start Date: 5/27/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat		0.00							
Powder Coating	Memo <i>M 111 274</i> *** put screws in nut plates before to keep thread clean***								
	START TIME: <i>9:10</i> OVEN TEMPERATURE: <i>325</i> FINISH TIME: <i>9:40</i>								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location <i>W1001</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

2 *15-6-19* *233*

(2) *15-06-22* *DAS 9 9-89*

(2) *15-06-22* *DAS 9 9-89*

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Wednesday, May 27, 2015 2:47:27 PM

Item ID: PB67-43001-79

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Blade Support Assembly

Start Date: 5/27/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5 JUN 23 2015

ML5 JUN 23 2015

Picklist Print

Wednesday, May 27, 2015 2:47:26 PM

Page 1

Work Order ID: 133237

133237

Parent Item: PB67-43001-79

PR67-43001-79

Parent Item Name: Lower Blade Support Assembly

Start Date: 5/27/2015

Required Date: 6/5/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-171

Manufactured

No

100

Each

87.0000

6

12

PR67-43001-171

Mounting Plate

Location

Loc Qty

Loc Code

Mezz2

87

112996

87

ME 15-5-27

PB67-43001-177

Manufactured

No

100

Each

10.0000

1

2

PR67-43001-177

Short Support Plate

Location

Loc Qty

Loc Code

Mezz2

10

99993

10

ME 15-5-27

PB67-43001-179

Manufactured

No

100

Each

12.0000

2

4

PR67-43001-179

Short Side Plate

Location

Loc Qty

Loc Code

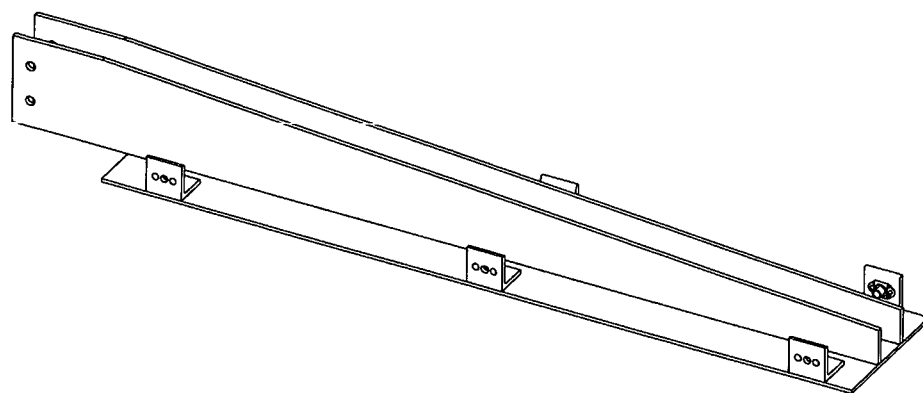
Mezz

12

113404

12

ME 15.5.27



B67-43001-79 LOWER BLADE SUPPORT ASSY

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE

#133237

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION			BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
DRAWN				SHEET 1 OF 2	
CHECKED		DRAWING NO.	B67-43001-79		
MFG. APPR.		TITLE	LOWER BLADE SUPPORT ASSY		
APPROVED		SCALE	NTS		
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
DATE	09.06.26				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

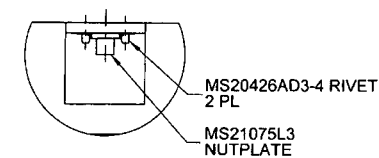
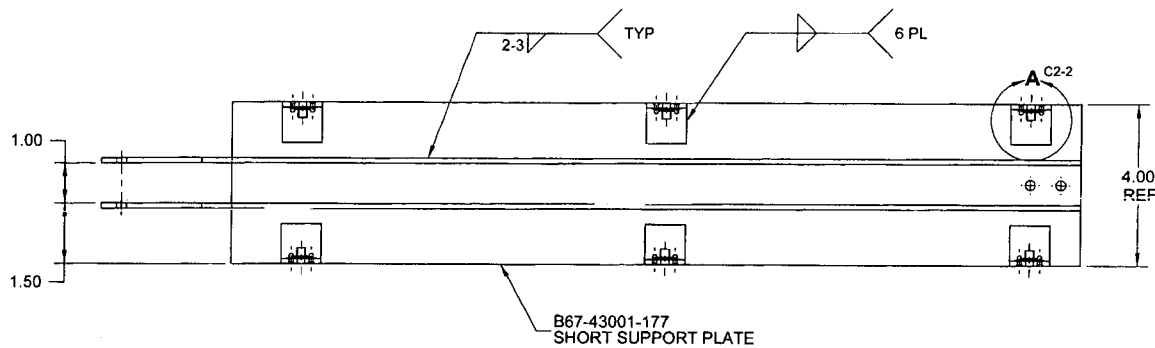
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

8 7 6 5 4 3 2 1

D

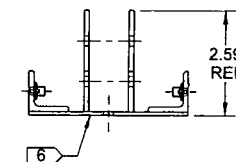
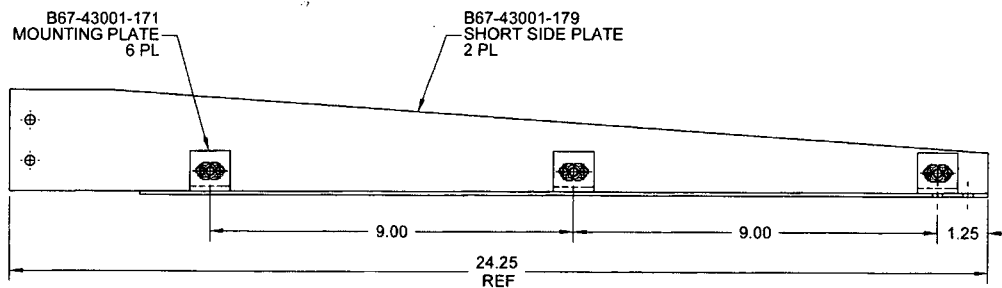
D



DETAIL A D4-2
SCALE 2X, 6 PL

C

C



B

B

B67-43001-79 LOWER BLADE SUPPORT ASSY

RELEASED
2009-09-24
MP

A

A

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-79	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					